

Work Order ID 64031

Page 1

November 23, 2010 10:07:50 AM

Item ID: D4055-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Tank Top

Start Date: 11/23/10 Start Qty: 3.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: C2

Date: 10/11/23 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4055	A

100

0.00



Waterjet

Memo

0.00

B10-10-9

FLOW CNC Waterjet

6061 -063

Cut as per dwg D4055

Prog rev: A

Dwg rev: A

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B10-10-9

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

 10 12 09 (3)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150



Packaging

Packaging

Identify as per dwg & Stock Location: 139ASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

10/12/9sf(3)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/14/10
10/12/129
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

November 23, 2010 10:07:50 AM

Work Order ID: 64031



Parent Item: D4055-1



Parent Item Name: Tank Top

Start Date: 11/23/10

Required Date: 11/30/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	41.2340	3.8639	12.20179			BB10-10-9

6061-T6 .063 Sheet



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT21	41.234	
113608	41.234	

116308

116308

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64031
Description: TANK TOP	Part Number:	D4055-1
Inspection Dwg: D4055-1, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

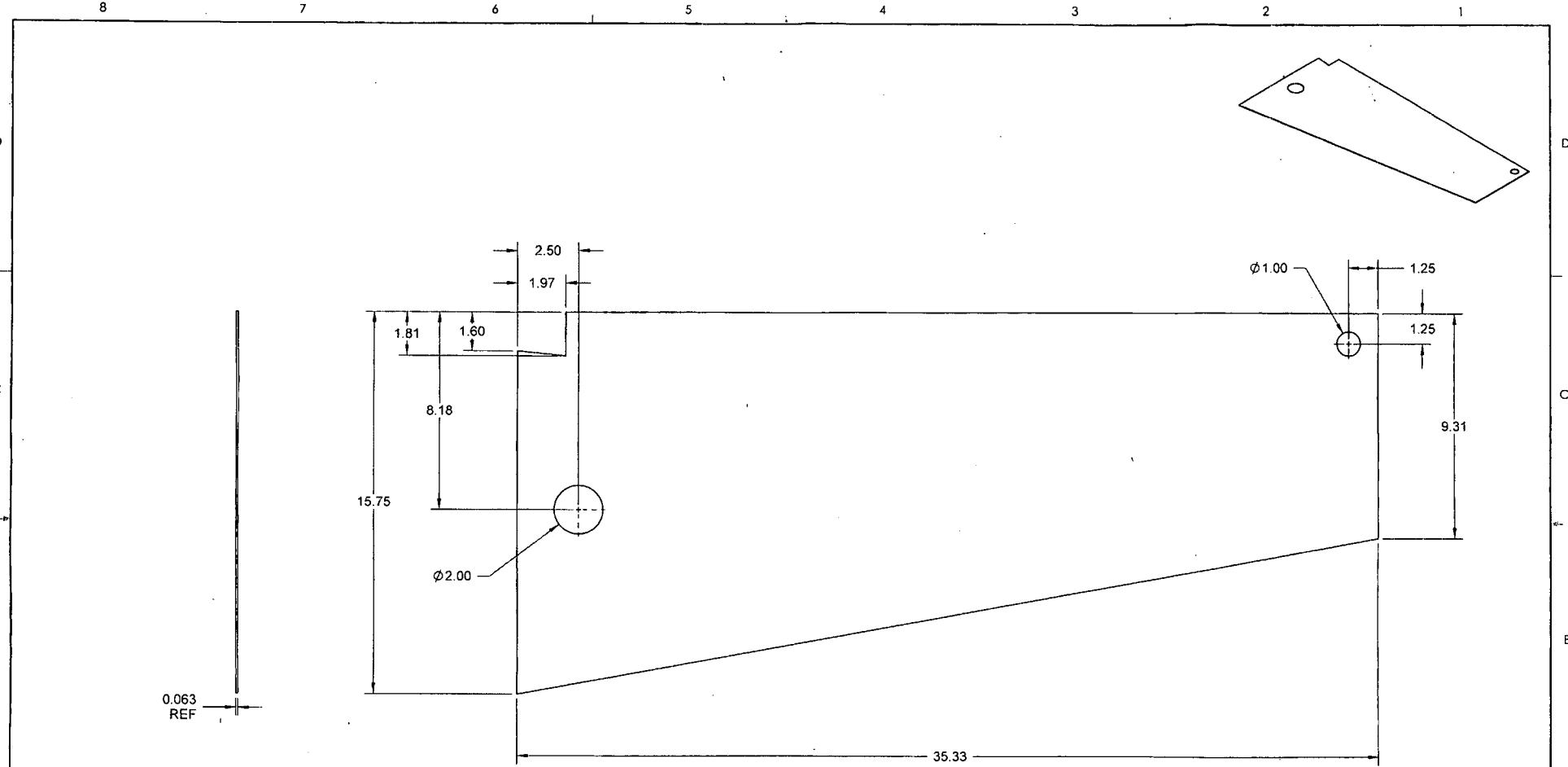
X First Article X Prototype

Measured by:	B
Date:	10-12-9

Audited by:	<u>M. M.</u>
Date:	10-17-09

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4055-1 TANK TOP

2011123
WIO:64031

RE-RELEASED
2010-05-05
M

A NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 REF DART SPEC M6061T6S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.68 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.	EZ	
APPROVED	140	
DE APPR.	-H	
DATE	10.04.16	
DRAWING NO.		REV. A
D4055		SHEET 5 OF 15
TITLE		SCALE
TANK		NTS
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